

Date: Thursday, 7/13/2006 3:37:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WASHER
 Job Number : 27895
 Estimate Number : 12298
 P.O. Number : N/A Part Number : D34931
 This Issue : 7/13/2006 S.O. No. : N/A Drawing Number : D3493 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27835 Material : N/A
 Written By : See Comment Below Due Date : 7/20/2006 Qty: 40 Um: Each
 Checked & Approved By : 06-07-13 W
 Comment : Est Rev: A New Issue 06-02-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1000 Inventory



Comment: Qty.: 0.0306 f(s)/Unit Total: 1.2222 f(s)

1.00" 304 ROUND BAR

(M304R1.000)

Batch: M100325

06/08/14

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA626 & Dwg D3493

2-Deburr

N/A Machined Manually
06/08/15 40

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/08/15 40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/08/16 40

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST2415

AR 06/02/16 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/08/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 27895

Part Number: D34931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: (15) 06/08/17

Job Completion



Handwritten: 06/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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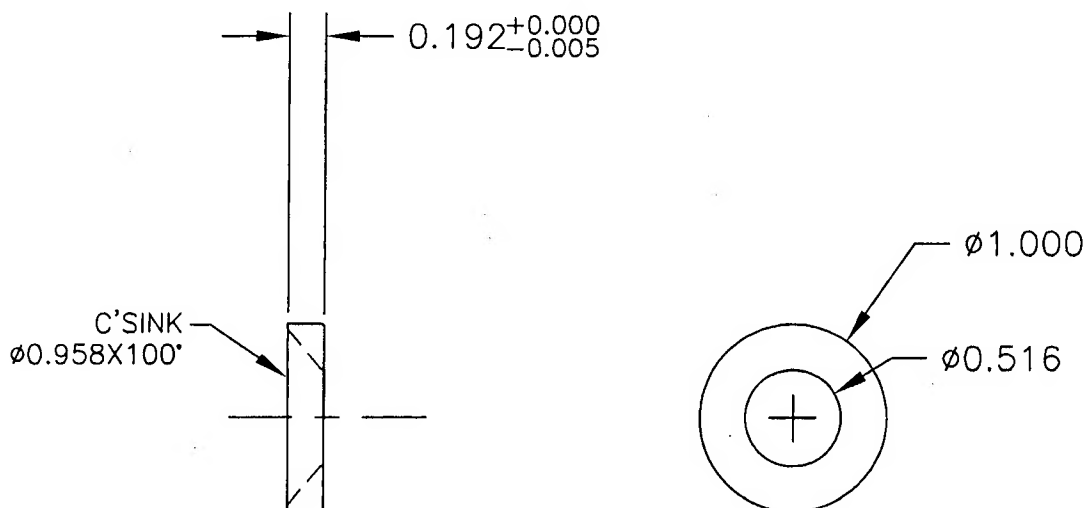
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE WASHER	SCALE 1:1
A	06.01.04	NEW ISSUE	



D3493-1 WASHER

D3493-1 WASHER

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ϕ 1.000 ROUND BAR
(REF DART MATERIAL SPEC M304R1.000)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27895

RELEASED
06.02.07 [Signature]

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